

Date: Monday, 11/05/2009 1:21:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR
Job Number : 47851	
Estimate Number : 12954	
P.O. Number :	Part Number : D32597
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3259 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 47192	Material :
Written By :	Due Date : 28/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09-05-11</u>	
Comment : Est Rev:A New Issue 07-07-19 JLM	Verified By: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4574 sf(s)/Unit Total : 14.5740 sf(s)
 2024-T3 .063sheet
 Batch: 111787 1B9-5-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3259
 Dwg Rev: A1 1B9-5-28
 Prog Rev: A1
 2-Deburr if necessary 1B9-5-28



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 09/05/09 1.2

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

112
1 mD 09/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:21:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 47851

Part Number: D32597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-01

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 181

09-06-02

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47851
Description: Door		Part Number: D3259-7
Inspection Dwg: D3259	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.008	+/-0.010	10.007	X			
9.000	+/-0.005	8.998	X			
1.000	+/-0.005	.998	X			
0.260	+/-0.010	.260	X			
R0.130	+/-0.010	.130	X			
5.960	+/-0.010	5.964	X			
0.548	+/-0.010	.551	X			
0.626	+/-0.010	.627	X			
11.250	+/-0.005	11.249	X			
Ø0.313	+0.005/-0.000	.314	X			
Ø0.098	+0.005/-0.000	.100	X			
3.308	+/-0.010	3.312	X			
R0.46	+/-0.030	.46	X			
0.063 thick	+/-0.010	.063	X			
0.059	+/-0.010	.066	X			

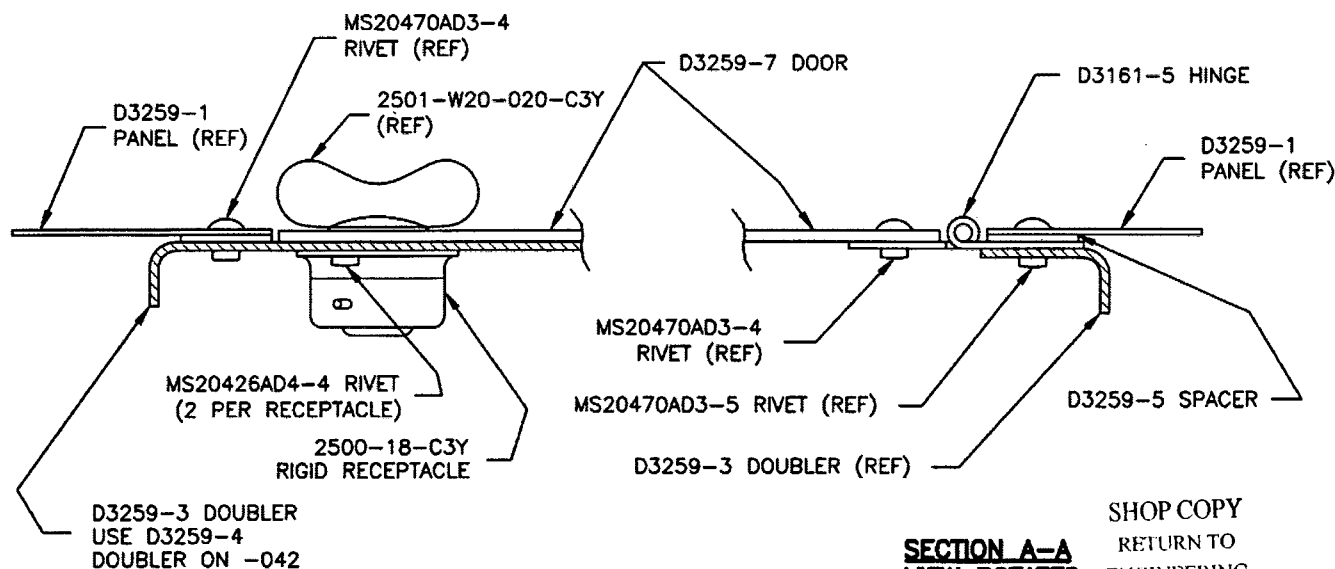
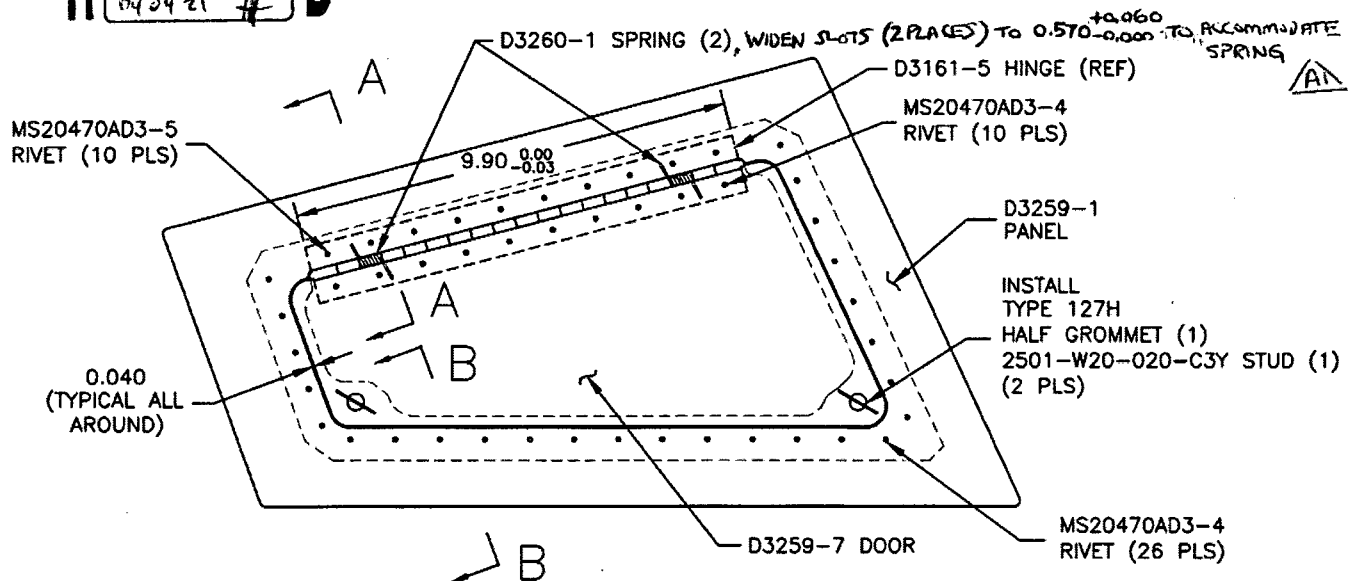
Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-5-28	Date: 09/05/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	



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				HAWKESBURY, ONTARIO, CANADA
CHECKED	TH	APPROVED	TH	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	CP	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING	

RELEASED
040421



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

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NO. 47851

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

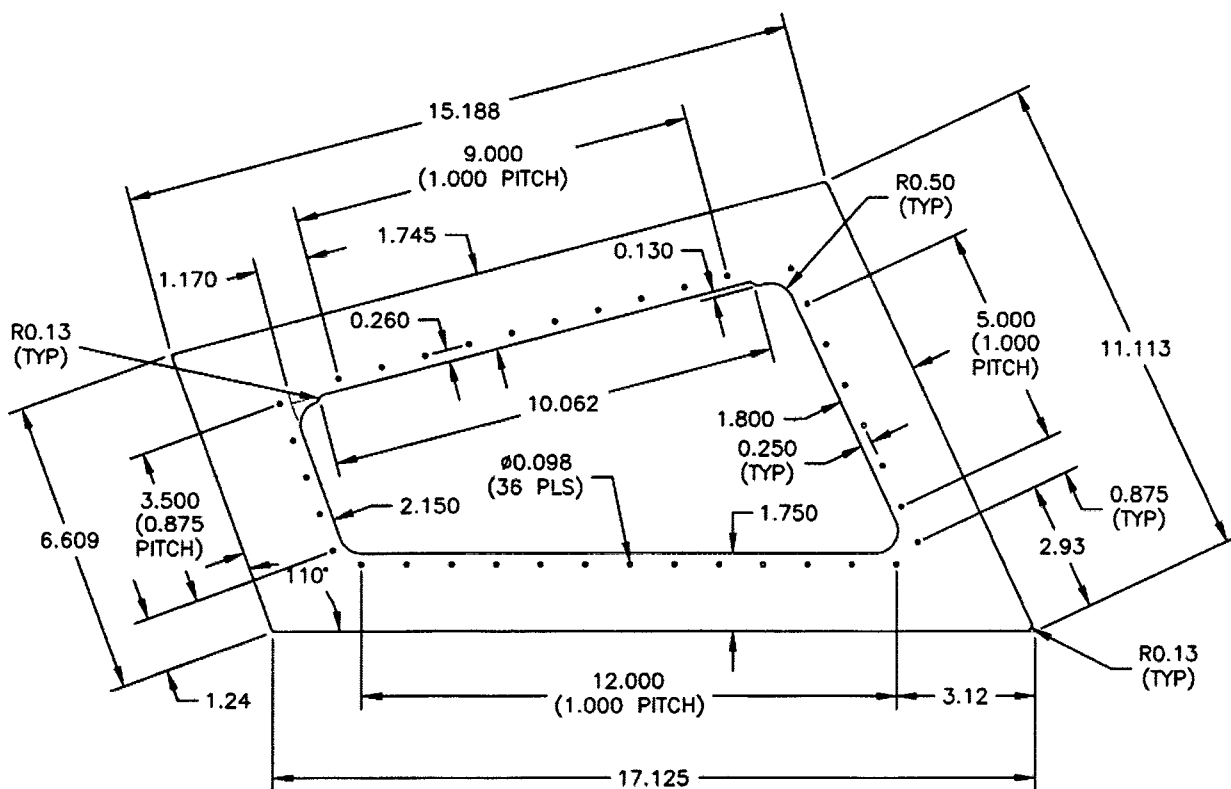
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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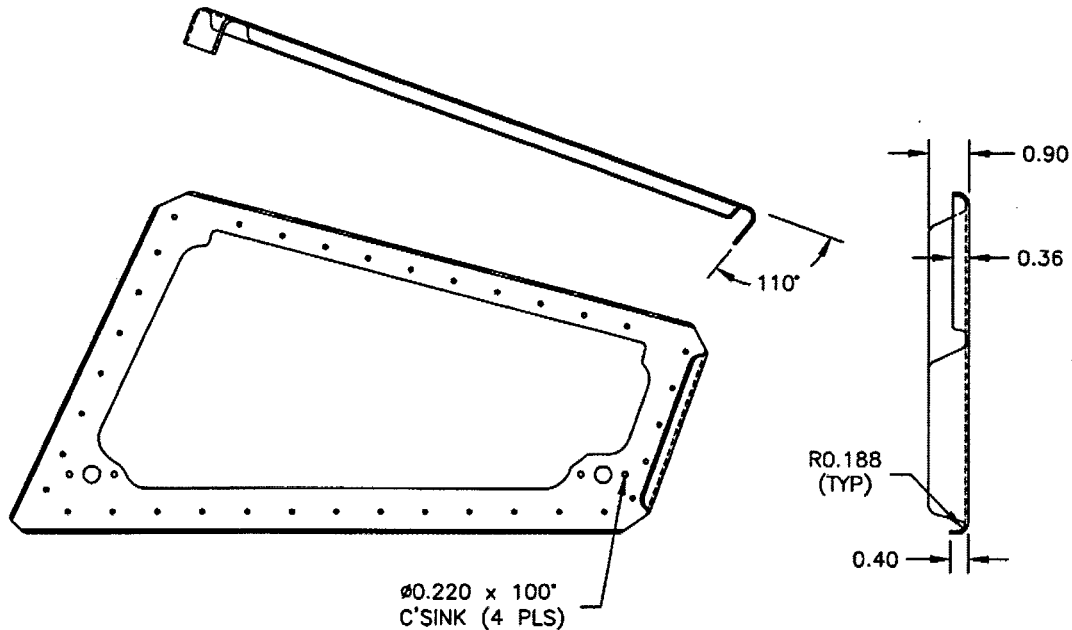
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RELEASED
04.04.14**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 SHOP COPY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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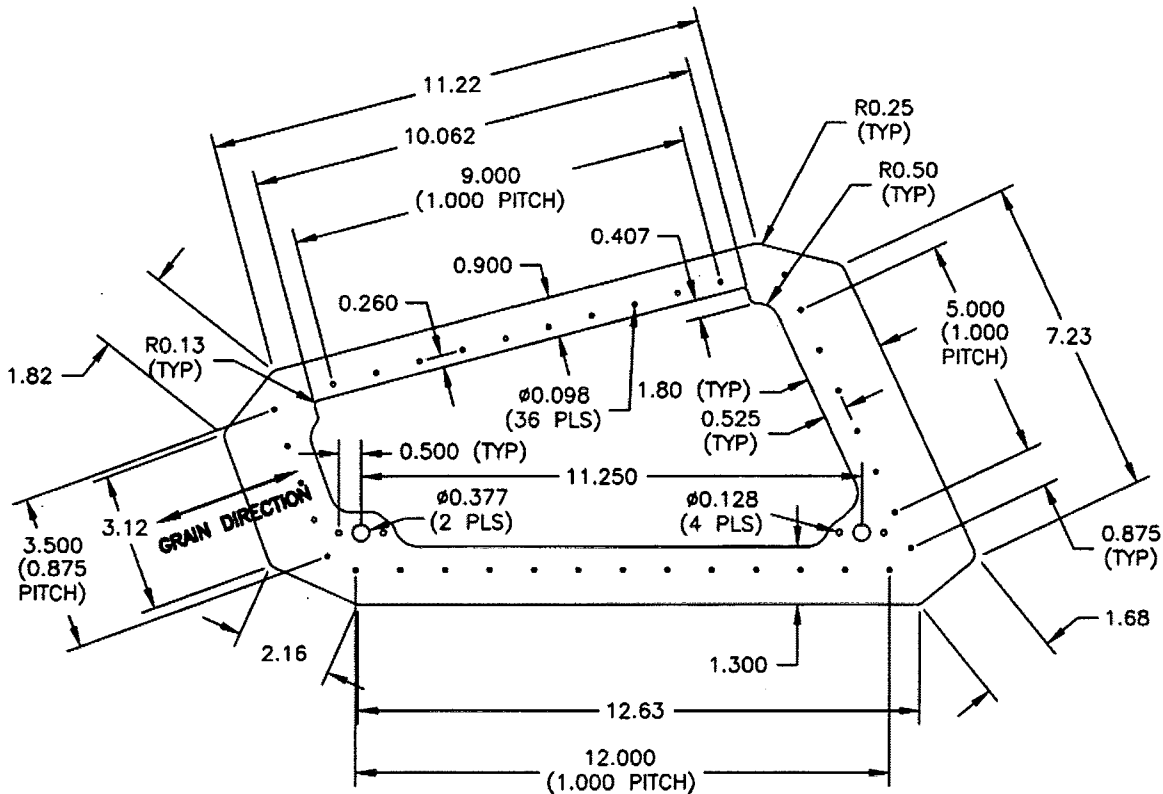
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04.04.14







D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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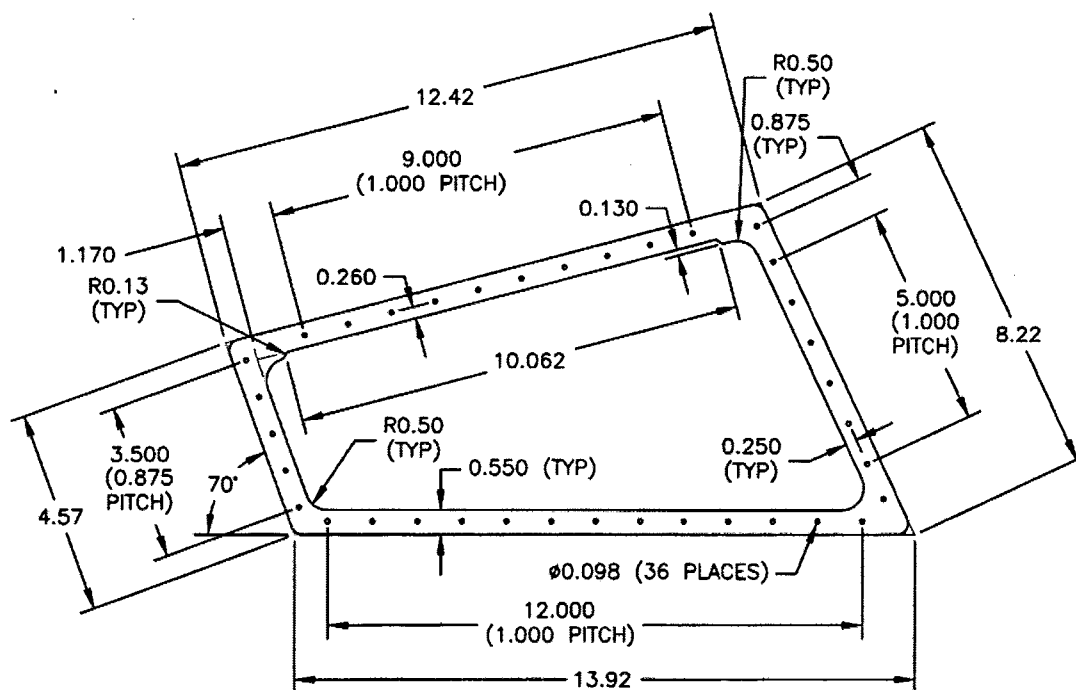
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04-04-05



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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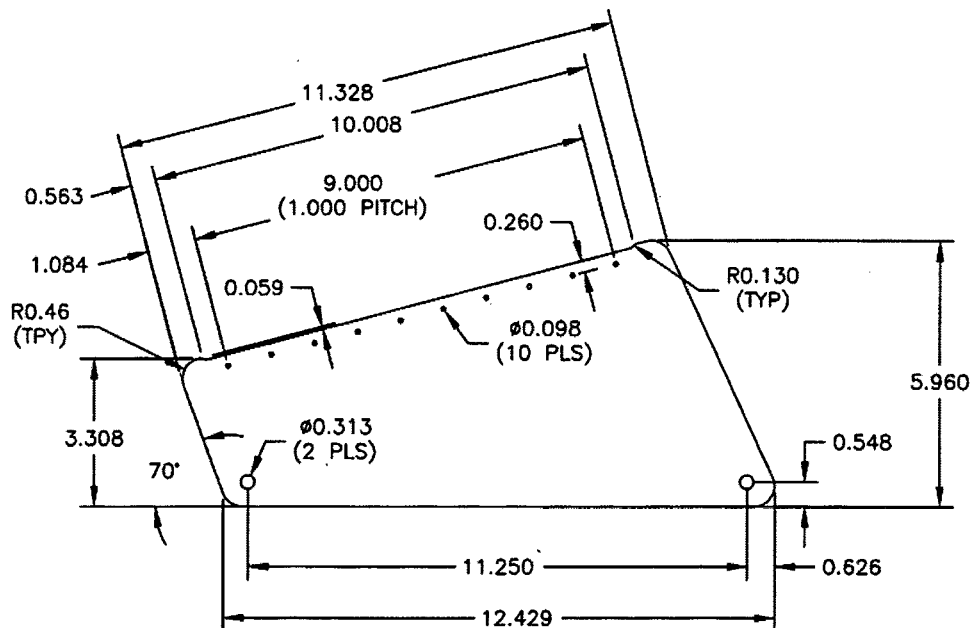
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04-04-14 *[Signature]*



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
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